

DART SERVICE INSTRUCTION

**SUPPLEMENTAL TO INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5
(REF. TCCA STC SH92-43, FAA STC SR01446NY & EASA STC EASA.IM.R.S.00709)**

PURPOSE

THE PURPOSE OF THE D412-698-025 KIT IS TO ALLOW OPERATORS THAT HAVE PERFORMED THE BELL/AUGUSTA SERVICE INSTRUCTION TA212-138/2-22B TO THE LH/RH CABIN DOORS TO REPLACE THE EXISTING P/N 205-031-435-001 & 205-031-435-002 ROLLERS WITH DART P/N D3121-143 & D3121-144 ROLLERS. THIS KIT ALSO REPLACES THE EXISTING DOOR TRACK WITH SEGMENTED "J" BRACKETS DART P/N D3675-3 (SEE FIGURE 3 FOR THE LOCATION OF BOTH CHANGES).

THERE IS A NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

PROCEDURE



- 1.) REMOVE HINGE PANEL DOOR PER AIRCRAFT MAINTENANCE MANUAL.
- 2.) REMOVE BELL P/N 205-031-435-001 AND 205-031-435-002 ROLLERS. RETAIN HARDWARE IF AIRWORTHY.
- 3.) REMOVE THE BELL/AUGUSTA DOOR TRACK. RETAIN HARDWARE IF AIRWORTHY.
- 4.) INSTALL DART P/N D3121-143 & D3121-144 USING EXISTING HARDWARE AND SHIMS IF AIRWORTHY. REPLACE EXISTING BELL SHIMS IF NO LONGER AIRWORTHY WITH WITH DART P/N D3238-3/-13 AS REQUIRED (SEE FIGURE 1). TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 5.) INSTALL THE DART P/N D3675-3 SLIDING DOOR BRACKETS ("J" BRACKETS) & THE D3202-5 COVER, PER FIGURE 2 USING EXISTING HARDWARE. TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 6.) RE-INSTALL MODIFIED DOOR ON AIRCRAFT PER AIRCRAFT MAINTENANCE MANUAL.
- 7.) CHECK SLIDING OPERATION OF DOOR. ADJUST POSITION/SHIMMING OF ALL NEW BRACKETS UNTIL DOOR OPERATION IS SMOOTH AND FREE OF DRAGGING/BINDING THROUGH FULL TRAVEL OF DOOR. RE-TORQUE ALL FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
NOTE: ENSURE VERTICAL ROLLERS ARE SITTING FLUSH TO THE DOOR TRACKS TO PREVENT ROLLER WEAR AND PREMATURE DOOR TRACK WEAR.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.11.04
CERT. NO.: SH92-43
ISSUE NO.: 5

B	ADD D3202-5 & D3675-3 & (COVER & "J" BRACKETS) CUSTOMER REQUEST TO REPLACE BELL/AUGUSTA MOD PARTS.	AJS	08.11.04
A	NEW ISSUE	AJS	08.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9409	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE PANEL ROLLER KIT	NTS
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D3121-144 BRACKET ASSEMBLY

D3121-143 BRACKET ASSEMBLY

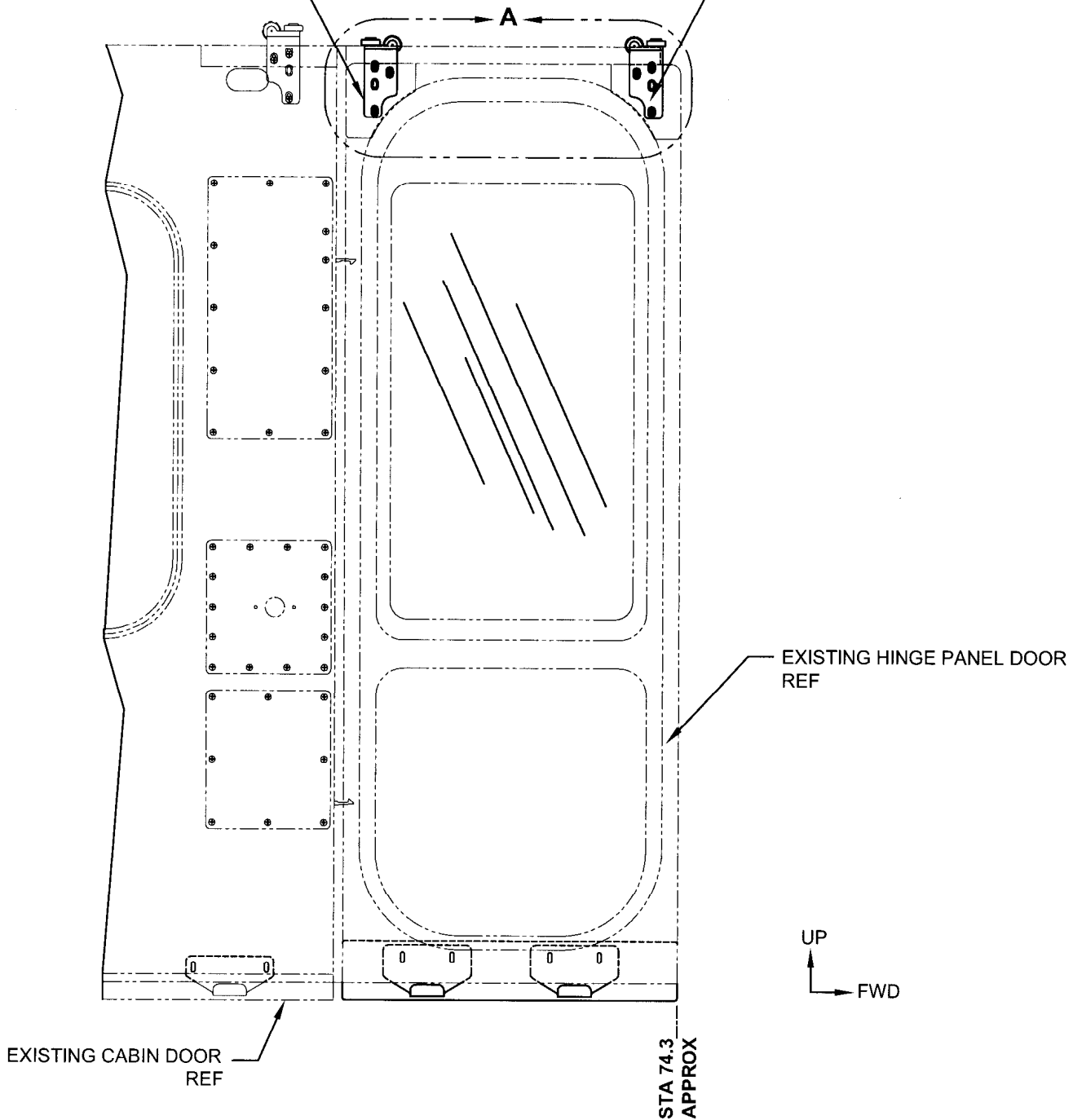


FIGURE 1. D412-698-025 HINGE PANEL DOOR ROLLER KIT
(VIEW OF L/H HINGE PANEL DOOR LOOKING OUTBOARD, R/H DOOR OPPOSITE)

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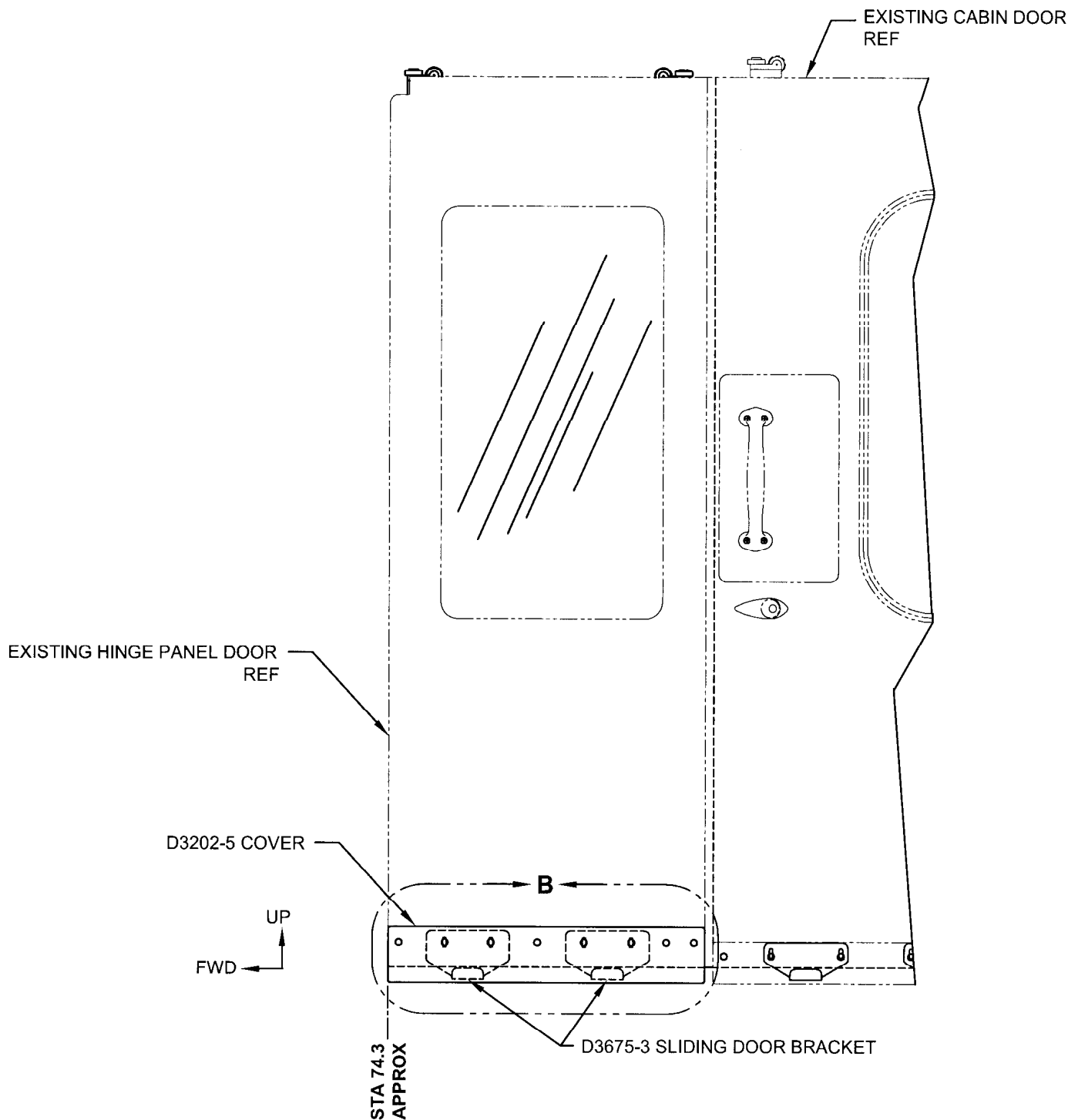


FIGURE 2. D412-698-025 HINGE PANEL DOOR ROLLER KIT
 (VIEW OF L/H HINGE PANEL DOOR LOOKING INBOARD, R/H DOOR OPPOSITE)

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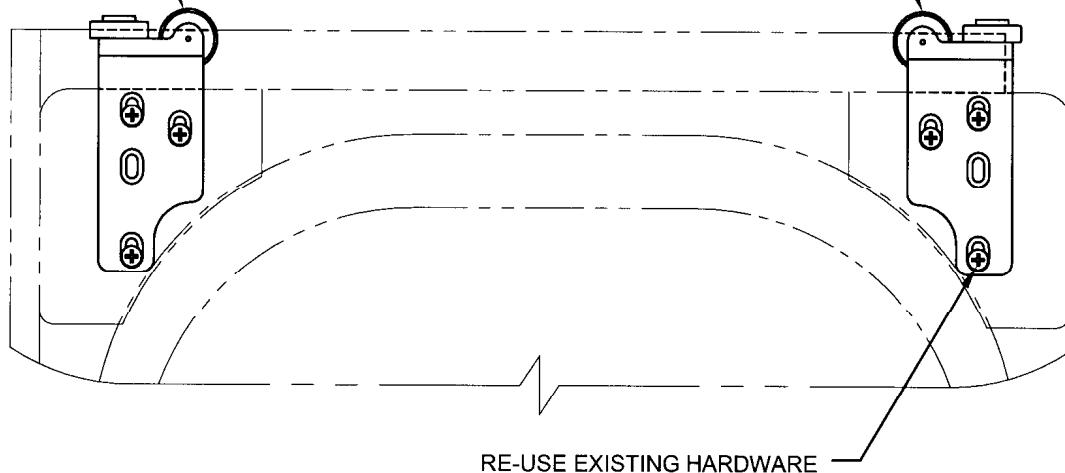
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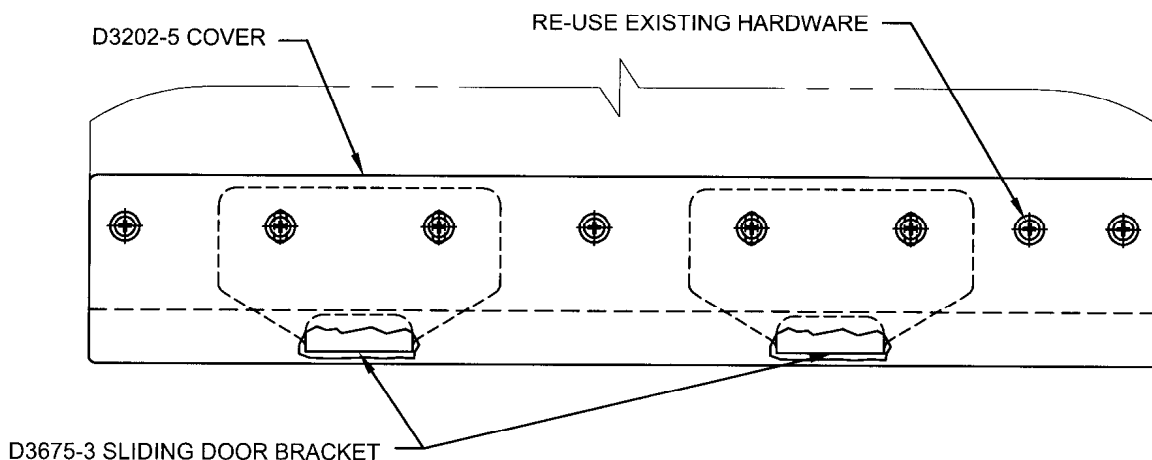
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(1) D3121-144 BRACKET ASSEMBLY REF
 (1) D3238-3 SHIM (AS REQUIRED)
 (1) D3238-13 SHIM (AS REQUIRED)
 LOCATE FROM EXISTING
 FASTENER HOLES

(1) D3121-143 BRACKET ASSEMBLY REF
 (1) D3238-3 SHIM (AS REQUIRED)
 (1) D3238-13 SHIM (AS REQUIRED)
 LOCATE FROM EXISTING
 FASTENER HOLES



DETAIL A VIEW ON L/H HINGE PANEL DOOR (LOOKING OUTBOARD)
 (RH DOOR OPPOSITE)



DETAIL B VIEW ON L/H HINGE PANEL DOOR (LOOKING INBOARD)
 (RH DOOR OPPOSITE)

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 AIRCRAFT CERTIFICATION
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 D. SHEPHERD (DE # 02)

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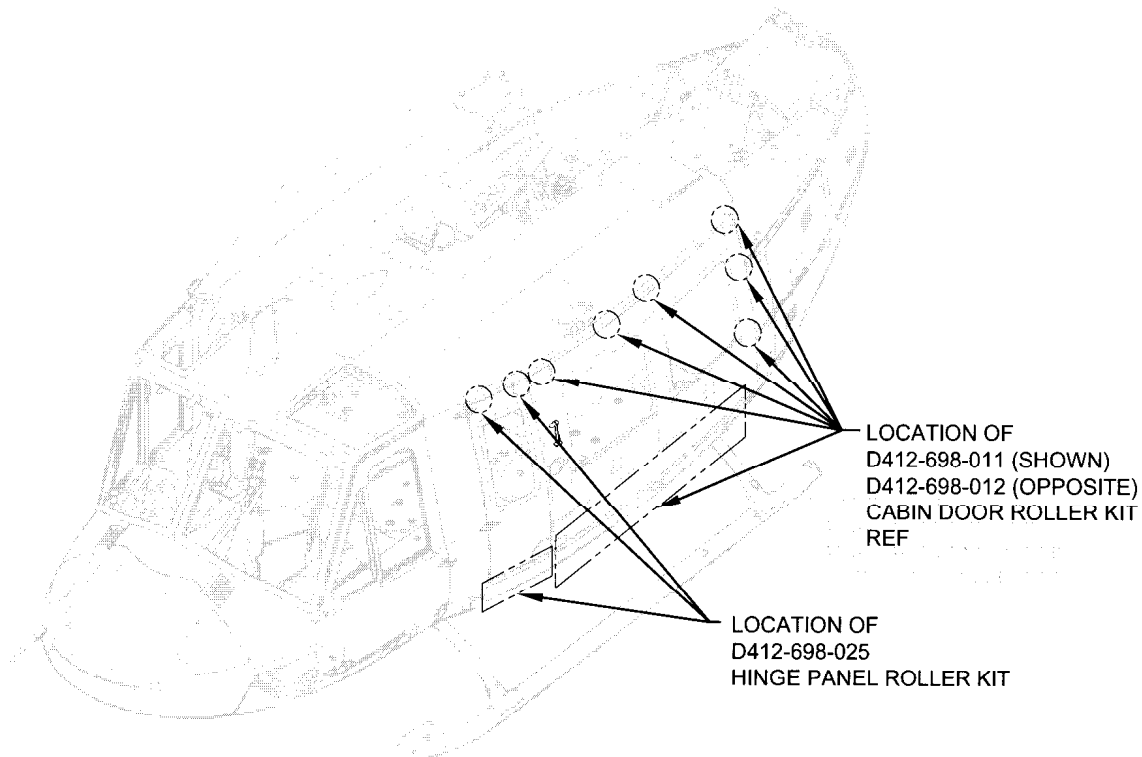


FIGURE 3. LOCATION OF D412-698-025 HINGE PANEL ROLLER KIT
(D412-698-011/-012 SHOWN FOR REFERENCE ONLY)

TABLE 1. PARTS LIST FOR D412-698-025

QTY -025	PART NUMBER	DESCRIPTION
X	PART NUMBER	HINGE PANEL DOOR ROLLER KIT (FITS L/H OR R/H DOOR)
1	D3121-143	BRACKET ASSEMBLY
1	D3121-144	BRACKET ASSEMBLY
1	D3202-5	COVER
2	D3238-3	SHIM
4	D3238-13	SHIM
2	D3675-3	SLIDING DOOR BRACKET

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